

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021734**Date Inspected:** 09-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** QBG & Tower**Summary of Items Observed:****Bay 1**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of welding weld repairs on Re-Built traveler rail assembly. ZPMC CWI Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20368

Weld- 20TR2-036-015, 017

WPS-345-FCAW-1G(1F)-ESAB-Repair

Welder-053609

1G/CJP/FCAW

WR20368

Weld- 20TR2-036-011

WPS-345-SMAW-1G(1F)-Repair

Welder-054467

1G/CJP/SMAW

WR20368

Weld- 20TR2-036-013, 009

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WPS-345-SMAW-1G(1F)-Repair  
Welder-057795  
1G/CJP/SMAW

### Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of welding on bike path assembly. ZPMC CWI Yu Dong Ping was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK008A2-002  
WPS-345-SMAW-1G(1F)-Repair  
Welder-046769  
1G/SMAW/CJP

### MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08499 from ZPMC for Bay 11. This QA inspector performed visual and magnetic particle test (MT) verification for Item 1, 2 after ZPMC had performed their MT inspection of the following locations;

#### Item 1

WSD1-DPSA6-4-5

#### Item 2

ESD1-DPSA6-2-5

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 03-09-2011 for additional information.

### UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08499 from ZPMC for Bay 11. This QA inspector performed ultrasonic test (UT) verification for Item 3, after ZPMC had performed their UT inspection of the following locations.

#### Item 3

ESD1-DPSA6-2-3, 4

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 03-09-2011 for additional information.

### Bay 10

This QA inspector observed ZPMC in process of FCAW welding on traveler rail assembly. ZPMC OC inspector was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Peng Fei as the CWI. It was stated that ZPMC had 9 welders and identified the welders by ZPMC

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welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 28TR1-012, 016, 009, 003, 006, 013

WPS-B-P-2212-TC-U5b

Welder- 0500363, 057220, 052493

2G/SMAW/CJP

Weld- 29TR1-006, 007, 009, 010

WPS-B-T-2132-ESAB

Welder- 040302

1G/SMAW/CJP

Weld- 26TR2-025

WPS-B-T-2232-ESAB

Welder- 040533

2G/FCAW/CJP

Weld- BK16B-001-015-016-017

WPS-B-P-2211-TC-U4c

Welder- 040365, 040581

1G/SMAW/CJP

Weld- BK15B-001-015, 020

WPS-B-P-2211-TC-U4c

Welder- 040582

1G/SMAW/CJP

Weld- BK15A-001-045

WPS-B-P-2312-TC-P4

Welder- 056364

2G/SMAW/PJP

HSR1 (B) 10144

Re-Built Traveler Rail

20TR2-030 & 20TR2-035

Trial Assembly

This QA inspector observed ZPMC in process of SMAW welding on Lift 12 segment assemblies. ZPMC CWI Wang Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

12AE

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Weld- CA6501-002  
WPS-B-P-2114-TC-U4b-FCM-1  
Welder- 067752  
4F/SMAW/CJP

12BE  
Weld- SEG3002F-133  
WPS-B-P-2113  
Welder- 040720  
3F/SMAW

12BE  
Weld- CA3005C-001  
WPS-B-P-2114  
Welder- 040484  
4F/SMAW

12BE  
Weld- CA3003D-015  
WPS-B-P-2114  
Welder- 052910  
4F/SMAW

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 150026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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